

Date: Wednesday, 05/11/2008 3:24:33 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG ASSEMBLY
Job Number : 43225	
Estimate Number : 10774	
P.O. Number :	Part Number : D3414041
This Issue : 05/11/2008 S.O. No. :	Drawing Number : D3414 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 05050	Material :
Written By :	Due Date : 14/11/2008 Qty: 6 Um: Each
Checked & Approved By : <u>JUL 08.11.05</u>	
Comment : Est A 05.09.13 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S12GA	304/316 0.100" Sheet
-----	-----------	----------------------



Comment: Qty.: 0.1523 sf(s)/Unit Total: 0.9135 sf(s)
 304/316 stainless steel 0.100" Sheet
 Batch: 10530 B 8-11-12

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3414
 Dwg Rev: A
 Prog Rev: A

B 8-11-12



2-Deburr if necessary B 8-11-12

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

06-11-12 (12)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE
 Deburr
 Form using DT8254 as per Dwg D3414

SN 08/11/25 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 05/11/2008 3:24:33 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 43225

Part Number: D3414041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5081225 (12)

7.0

D34143

Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Lug

Pick:

Qty

Part Number Description

Batch

1

D3414-3

Lug

A/R

SS Rod

~~B37432~~ X6 6X B43705 ✓
M106115

EL 8-12-8

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld using location Jig DT8484 as per Dwg D3414

~~6X done in~~

EL 8-12-8 (12)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

pld 08-12-08
R 08-02

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5081225/08 (12)

11.0

POWDER COATING

POWDER COATING



M109152



(12X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

10:40

OVEN TEMPERATURE:

400 °F

FINISH TIME:

11:10

M-1 08/12/09

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-12-09

(12X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: LUG ASSEMBLY

Job Number: 43225

Part Number: D3414041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST472

SS 08/10/11 (X12)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/11 JA

Job Completion



mt 08-12-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

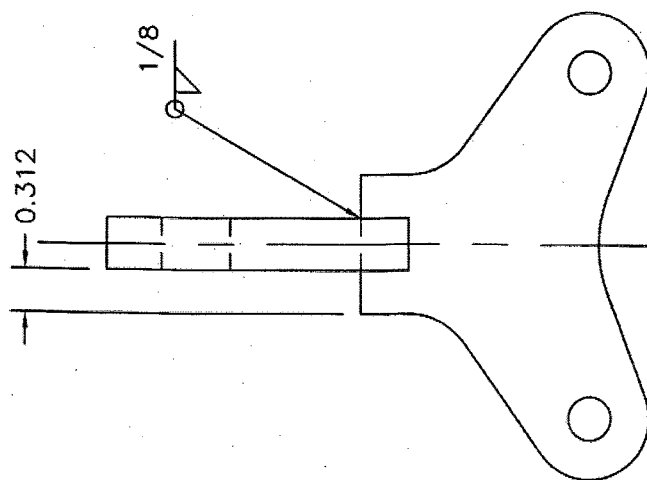
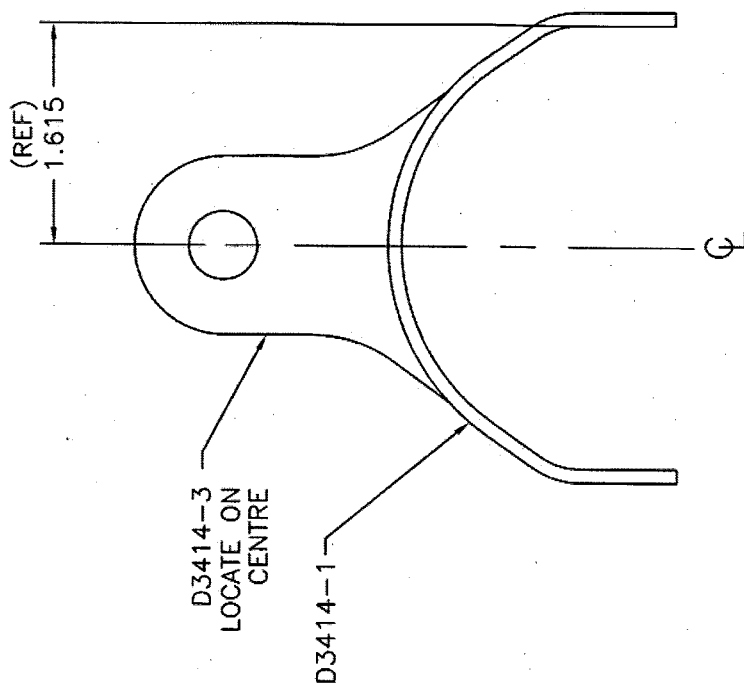
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DATE 05.03.16		TITLE LUG ASSEMBLY	SCALE NTS
A	05.03.16	NEW ISSUE	

RELEASED
05-09-06



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WORK ORDER
NO. 34225

D3414-041 LUG ASSEMBLY

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRIC ABOUT CENTERLINE

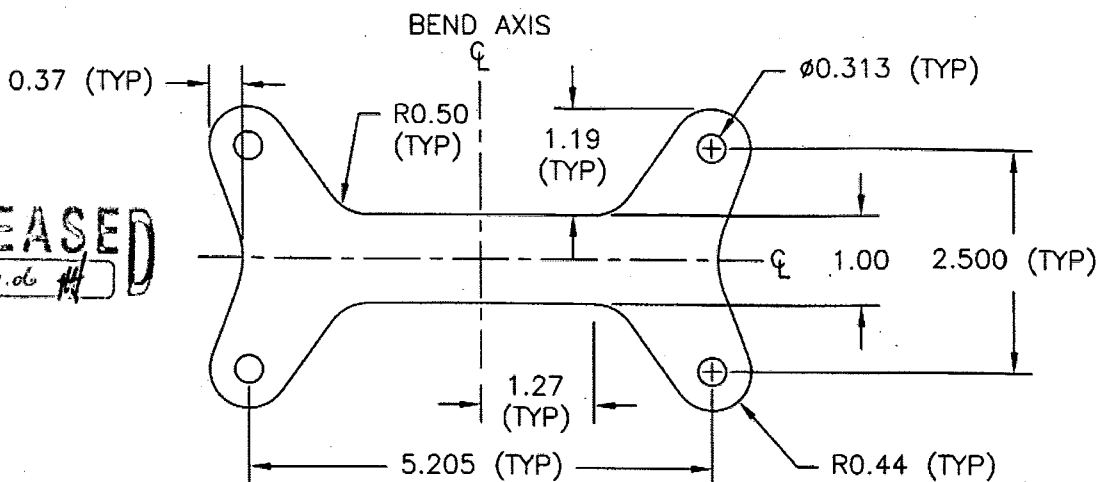
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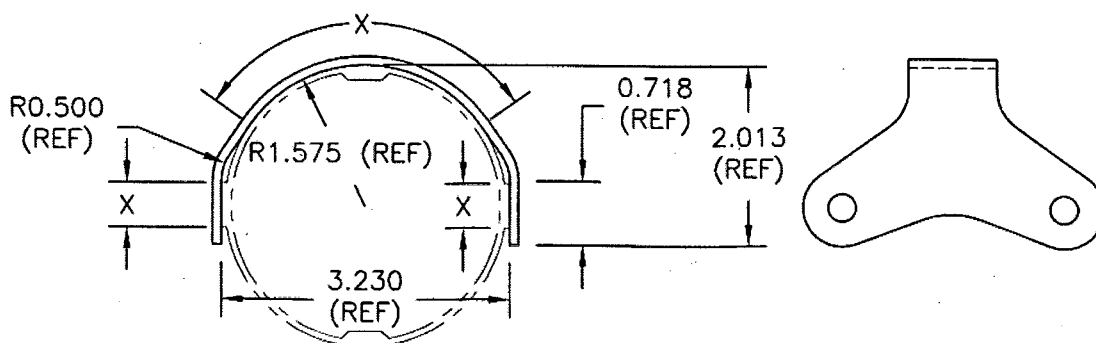
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DATE 05.03.16	TITLE LUG ASSEMBLY		SCALE 1:2

RELEASED
05.09.06 *[Signature]*



D3414-1 FLAT PATTERN

SYMMETRICAL ABOUT BOTH CENTRE-LINES (CL)



D3414-1 BEND DETAIL

D3414-1 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

D3414-1 LUG BRACKET

- 1) MATERIAL: AISI 304/316 SS SHEET 0.100 THICK (12 GAUGE, REF DART SPEC. 304S12GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

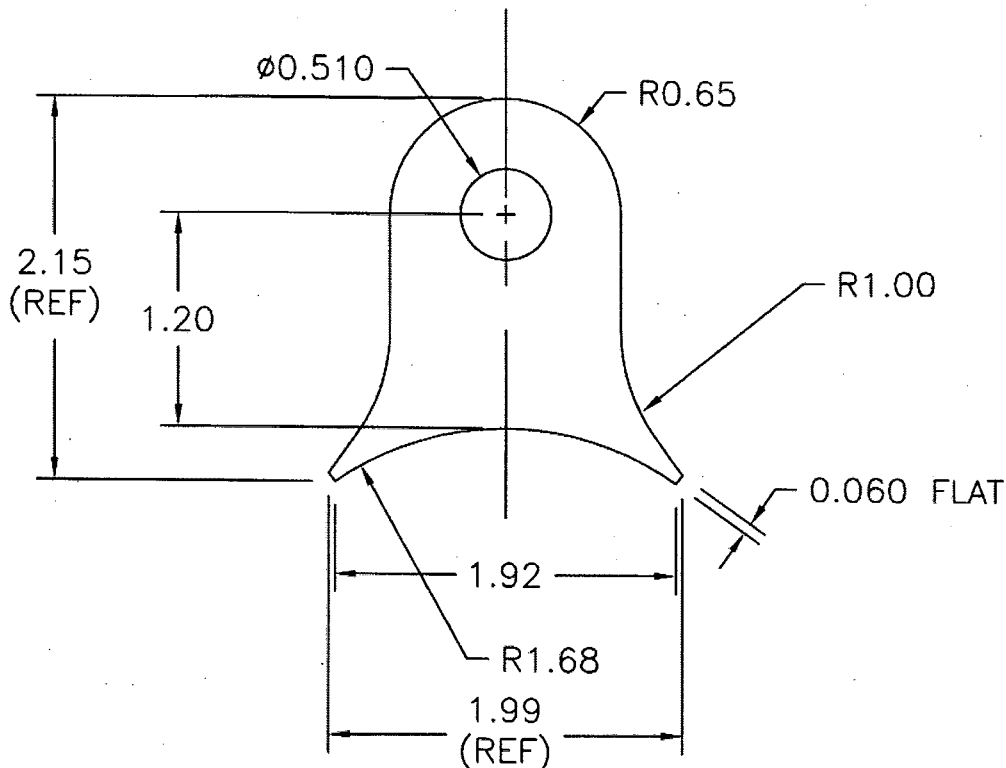
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3414	REV. A SHEET 3 OF 3
DATE 05.03.16		TITLE LUG ASSEMBLY	SCALE 1:1

RELEASED
05-07-06 *[Signature]***D3414-3 LUG**

- 1) MATERIAL: AISI 304/316 SS PLATE 0.375 THICK (REF DART SPEC. M304S)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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